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D5491-041
Job Sheet 196241



Part No: D5491-041

Job Qty: 7 pcs

Part Name: Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D5491 REV:B IPP REV:A 18.04.04 NEW ISSUE DD VERF:JFS IPP REV:B 18/08/02 AS PER DWG REV.B
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	7 pcs	6/28/19		0.00	58.33	Small Fab - 1		DAS 58 9-89 17/7/23
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	7 pcs	6/28/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 JUL 24 2019 19-7-29
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Spray Paint - 2 - B4B	7 pcs	6/28/19		0.00	3.50	Spray Paint - 1 - B4B		DAS 40 9-89 JUL 24 2019 19-7-29
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
140	QC 14	7 pcs	6/28/19		0.00	0.00	QC 14 - 15		
							QC 14 - 2		

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					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	DAS
					QC 14 - 40	JUL 31 2019 40
					QC 14 - 19	9-89
					QC 14 - 43	
					QC 14 - 24	
150	Handfinish - 3-1- WingWalk-B4B	7 pcs	6/28/19	0.00 3.50	Handfinish - 3 - 1 - B4B	11-19-8-1
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
160	QC 3	7 pcs	6/28/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	DAS
					QC 3 - 34	61
					QC 3 - 36	9-89
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
170	Packaging 3-1 - Stock - B4B	7 pcs	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA				7 pcs	6/28/19
				0.00	0.00
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

21
2-22

AUG 07 2019

Fg dock

Part Op 110 - 1- ASSEMBLE FIXTURE DT10384 WITH BLOC "A", "B" AND "C" TO MANUFACTURE D5491-041. 2- ASSEMBLE
 Descriptions: D5273-043 FITTINGS TO D5491-1 STEP WITH PROSEAL AS PER DWG A/R PROSEAL: 5194525 3- INSERT
 ALL PARTS TOGETHER IN FIXTURE DT10384 AND TRANSFER DRILL HOLES USING DT10186 FOR D5499-1 AND
 DT 10185 FOR D5499-1 AS PER DWG AND NOTES 8,9. 4- DISASSEMBLE AND DEBURR. 5- a) USE DT10170 DRILL
 JIG TO DRILL NUT PLATE HOLES IN D5627-1 TUBE AS PER DWG. b) DEBURR c) TOUCH UP HOLES WITH
 ALODINE ONLY d) INSTALL NUTPLATES IN TUBES 6- TOUCH UP HOLES WITH ALODINE ONLY ON D5627 AND
 D5273-041 FITTINGS. 7- USE DT10384 TO RE-ASSEMBLE REST OF THE PARTS TOGETHER USING PROSEAL AS
 PER DWG A/R PROSEAL: 5194525 CURE TIME 24h: ✓
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Spray Paint / NDT Room) Prime and paint as per dwg. ***MASK SLOTS AS PER NOTE 10***
 140 - (QC14- Inspect Spray Paint)
 150 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 1- MASK SCREWS AS PER DWG AND APPLY WING WALK
 AS PER DWG. 2- INSTALL PLACARD AS PER DWG. (NOTE11)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR3212-4-05	Cherry Rivet	42 Ea (6 ea)	110-Small Fab - 1	ST320
CR3242-4-4	Rivet	56 Ea (8 ea)	110-Small Fab - 1	ST318
D5273-043	End Fitting Assembly	7 pcs (1 ea)	110-Small Fab - 1	ST227A
D5291-041	Radius Block Assembly	21 pcs (3 ea)	110-Small Fab - 1	ST151
D5491-1	Step Extrusion	7 pcs (1 ea)	110-Small Fab - 1	GA T8D
D5499-1	Aft Bracket Mount	7 pcs (1 ea)	110-Small Fab - 1	GA119
D5625-1	Receptacle	28 pcs (4 ea)	110-Small Fab - 1	ST179
D5627-1	Tube	7 pcs (1 ea)	110-Small Fab - 1	GA113
D5629-041	End Cap Assembly	7 pcs (1 ea)	110-Small Fab - 1	GA119
MS21042L3	Nut	14 Ea (2 ea)	110-Small Fab - 1	ST303
MS24694-S50	Screw	56 Ea (8 ea)	110-Small Fab - 1	ST284
MS24694-S98	Screw	21 Ea (3 ea)	110-Small Fab - 1	ST283
MS27039-1-10	Screw	7 Ea (1 ea)	110-Small Fab - 1	ST280
MS27039-1-30	Screw	14 Ea (2 ea)	110-Small Fab - 1	GA200
NAS1149D0332J	Washer	14 Ea (2 ea)	110-Small Fab - 1	ST264
NAS1149D0363J	Washer	28 Ea (4 ea)	110-Small Fab - 1	ST264
D2137	Decal(No Step)	7 pcs (1 ea)	150-Handfinish - 3-1- WingWalk-B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CR3212-4-05	42	122	0
	CR3242-4-4	56	254	0
	D5273-043	7	12	0
	D5291-041	21	129	0
	D5491-1	7	0	0
	D5499-1	7	0	0
	D5625-1	28	56	0
	D5627-1	7	6	0
	D5629-041	7	5	0
	MS21042L3	14	1,770	0
	MS24694-S50	56	311	0
	MS24694-S98	21	115	0
	MS27039-1-10	7	341	0
	MS27039-1-30	14	10	0
	NAS1149D0332J	14	3,288	0
	NAS1149D0363J	28	1,314	0
150-Handfinish - 3-1- WingWalk-B4B	D2137	7	51	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S199704



Part: D5491 - 041

Job No: 196241

Serial No/Batch: S199704

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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